Work Ord June-24-13 1:5		3394		*103	3394*	<del></del>					Page 1
Item ID: Revision ID: Item Name:	D3208-11 Filler			Accept	*N90	<b>004</b> 0	100	<b>)*</b> s	etup Star Sto	1.7	S1* S2*
Start Date: Required Date Reference:	6/24/13 : 7/05/13	Start Qty: 8.00 Req'd Qty: 8.00	• •		Cust Ite Custom						
Approvals:		in: <u>M</u> して		Tooling:  SPC (Y/N):		Date:		R	tun Star Stop	" <b>[V</b> ]	R1* R2*
Sequence ID/ Work Center I	ID .	Operation Description		Set Up/ Run Hours	Tool I	D Tool#	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Rev	ision Nbr									
D3208	С										
*100 *100*		FLOW WATER JET		0.00				8	0		Ac 38.0
Waterjet FLOW CNC Water (OCCE) · OCC	-	Dwg Re Prog Re	s per Dwg D3208 ev:C v:C rr if necessary	0.00						· · · · · · · · · · · · · · · · · · ·	73.08.0
*110*		QC2- Inspect parts o	ff machine FAI/FAIB	0.00				8	Q	·	A
QC		Memo		0.00	l l						13.08.

Quality Control

DQA:	Date:							ΔART	•					
QA Closed:		Date:			WORK ORDER NON-	-C(	ONFO	RMANCE / UPDATE	W	ork Order u	ndate only	$\neg$	AEROSPACE	
diversion of		Bute.												
Work Orde	er:				DISPOSITION		AGAINST DEPARTMENT/PROCESS							
	-				Rework Skid-tube Crosstub			e	e Water Jet Engineering					
Part N	lo				Scrap	Scrap Machining Small Fab Prod. Eng. Coor.					Quality			
					Use-as-is	-is Thermoforming Finishing Rec/Store/Packaging					Other			
NCR N	lo			_	Suspected Unapproved	]		Large Fab Composit	:e	<u> </u>	Supplier			
Root			ľ	Descr	ription of work order update		Initial	Action		Sign &				_
Cause	Date	Step	Qty		or non-conformance	Ch	nief Eng	Description		Date	Verification	1	QC Inspector	
Design														
Doc/Data														
Equip/Tooling						ĺ					İ			
Handling/Pre													•	
Material							•							
Operator														
Offset/Setup	_													
Process														
Supplier						1					]			
Training											ĺ			
Transport														
Unapproved		j						, ·						
						FA	ULT CA	TEGORY						
Landir	ng Gear				General		,		_	_	,			
	Bendin	-		ļ	Bend	_	Folio/F	Program		Outside Dim	ensions	P	ressure/Forced	
	Centre	Not Conce	ntric	<u> </u>	BOM/Route	_	Grain			Over/Under	tolerance	S	et-up	
	Cracks				Broken/Damage/Defect		Hardwa	ire	L	Part Incorre	ct	T(	emperature/Cure	
	Crimp/	Kink/Ripple	e/Wave	<u> </u>	Burrs	L	Inspect	ion Incomplete/Unqualified		Part Lost/Mi	issing	\^	Veld	
	Cuffs				Contamination	L	Instruct	tions Incomplete/Unclear		Part Moved		\v	rong Stock Pulled	
	Crushing			Countersink		Misalig	gned/off center	L	Positioned V	Vrong	_			
	Heat Treat			Cut Too Short		Mislabe	eled		Power Loss/	Surge	0	ther		
ļ	Inspect	ion Strip in	Tube		Drawing		Misread	t						
		Chatter			Drill Holes		Off-set							
ļ	Turning	Sequence	•		Finish	L	Out of	Calibration						
	Wave/	wist in Tul	be		Fit/Function		Out of 9	Sequence			_ <del></del>			

Work Orde		3394		*1033	94*				Page 2
Item ID: Revision ID: Item Name:	D3208-11			Accept *	N90004	<b>L</b> 0100	)* Se	etup Start Stop	*NS1* *NS2*
Start Date: Required Date: Reference:	6/24/13 : 7/05/13	Start Qty: 8.00 Req'd Qty: 8.00	*8* *8*		Cust Item ID: Customer:				
Approvals:		n:		Tooling: SPC (Y/N):	Date: Date:		R	un Start Stop	*NR1* *NR2*
Sequence ID/ Work Center II 120 *120 *120 *120 QC Quality Control	<b>D</b> .	Operation Description QC8- Inspect parts - second Memo	and check	Set Up/ Run Hours 0.00 23 0.00 13, 8-7	Tool ID To	ol # Plan Code	Accept Qty		Reject Insp. Number Stamp
*130 *130* HandFinish Hand Finishing		Chemical Conversion Co	oat per QSI005 4, I	0.00			8	W	13.81.7
140 <b>*1 1 1 1 1 1 1 1 1 1 </b>		QC7-Inspect Chemical (	Conversion Coat	0.00			8		

DQA:		_ Date:			"οΔΕ							TOART	
QA Closed:		Date:			WORK ORDER NON-	-CONFORMANCE / UPDATE  Work Order update only							
QA Closed.		Date.											
Work Orde	er:				DISPOSITION			AGAINST	DE	PARTMENT	/PROCESS		
					Rework		Skid-tube Crosstub			]	Water Jet	Engineering	
Part N	lo				Scrap			Machining Small Fab		Pro	d. Eng. Coor.	Quality	
	-				Use-as-is		Therr	moforming Finishing		Rec/Sto	re/Packaging	Other	
NCR N	lo				Suspected Unapproved	j		Large Fab Composite	L.	J	Supplier		
Root				Desci	ription of work order update		nitial	Action		Sign &	i		
Cause	Date	Step	Qty		or non-conformance	1	ief Eng	Description		Date	Verification	QC Inspector	
Design				ı									
Doc/Data													
Equip/Tooling						ŀ							
Handling/Pre							_						
Material							\$						
Operator													
Offset/Setup			1										
Process													
Supplier			ļ			l							
Training								·					
Transport													
Unapproved													
						FAU	ULT CA	TEGORY					
Landir	ng Gear				General		_						
	Bending				Bend		Folio/F	Program		Outside Dim	ensions	Pressure/Forced	
	Centre N	lot Conce	ntric		BOM/Route		Grain			Over/Under	tolerance	Set-up	
1	Cracks				Broken/Damage/Defect		Hardŵa			Part Incorre	ct	Temperature/Cure	
	Crimp/K	ink/Ripple	/Wave		Burrs		Inspect	ion Incomplete/Unqualified		Part Lost/Mi	issing	Weld	
	Cuffs			Contamination		Instruct	tions Incomplete/Unclear		Part Moved		Wrong Stock Pulled		
[	Crushing			Countersink		Misalig	ned/off center		Positioned V	Vrong			
			Cut Too Short		Mislabe	eled		Power Loss/	Surge	Other			
			Drawing		Misread	d		_	_				
	Marks/C	hatter			Drill Holes		Off-set						
	Turning	Sequence			Finish		Out of (	Calibration					
	Wave/Tv	wist in Tub	oe		Fit/Function		Out of S	Sequence					

Work Orde June-24-13 1:54		3394		*1033	94*		_	Page 3
Item ID: Revision ID:	D3208-11	`		Accept *	N900040	100* Set	up Start	INCL
Item Name:	Filler				:		Stop	*NS2*
Start Date:	6/24/13	Start Qty: 8.00	*8*		Cust Item ID:			
Required Date:	7/05/13	Req'd Qty: 8.00	*8*		Customer:			
Reference:							<b></b>	
Approvals:	Process Pla	n:	Date:	Tooling:	Date:	Rui		"NRT"
	QC:		Date:	SPC (Y/N):	Date:		Stop	*NR2*
Sequence ID/ Work Center II	)	Operation Description	ock Location:57202	Set Up/ Run Hours	Tool ID Tool #	•	Reject Qty	Reject Insp. Number Stamp
*150 *150* Packaging		Memo	ock Location.	0.00	<u>.</u>	<u>8</u> x	- <b>'</b>	W. 13-08-8
160 *160* QC Quality Control		QC21- Final Inspection  Memo	- Work Order Release	0.00		1 - 7	3·8·8	-08 12

DQA:	<del> </del>	Date	·		WORK ORDER NON-CONFORMANCE / UPDATE								<b>*</b> ∂ΔRT
QA Closed:		Date	:		WORK ORDER NON-	-C(	ONFO	RMANCE / U	IPDATE	W	ork Order uj	odate only	AEROSPACE
					DISPOSITION								
Work Orde	=1.				Rework	1		Skid-tube	Crosstube		1	Water Jet	Engineering
Part N	JO.				Scrap		Machining Small Fab Prod. Eng. Coor.						Quality
1 4101	····				Use-as-is			noforming	Other				
NCR I	No.				Suspected Unapproved			Large Fab	Finishing Composite	_	1111,111	re/Packaging Supplier	
						,			<u> </u>			· · · · ·	
Root				Desc	ription of work order update	ı	Initial	Ac	tion		Sign &		
Cause	Date	Step	Qty		or non-conformance	Ch	nief Eng	Desc	ription		Date	Verification	QC Inspector
Design	_												
Doc/Data				ŀ									
Equip/Tooling			į										
Handling/Pre													
Material													
Operator	_												
Offset/Setup	$\vdash$												
Process													
Supplier													
Training						1							
Transport												<u> </u>	
Unapproved			.!		· · · · · · · · · · · · · · · · · · ·	<u> </u>	III T CAT	[ FEGORY			<u> </u>	1	
Landi	ng Gear				General	FAI	ULI CA	EGORT					
Carrain	Bendir	ıσ		Ť	Bend		Ealio/E	rogram		Г	Outside Dim	ensions [	Pressure/Forced
	— .	Not Conce	ntric		BOM/Route	-	Grain	rogram			Over/Under	<del>-</del>	Set-up
	Cracks				Broken/Damage/Defect		Hardwa	re			Part Incorre	<del>-</del>	Temperature/Cure
	_	/Kink/Ripple	e/Wave		Burrs		1	ion Incomplete/U	Inqualified		Part Lost/Mi	<del>)</del>	Weld
	Cuffs		•		Contamination		-{	ions Incomplete/		一	Part Moved		Wrong Stock Pulled
	· Crushing				Countersink		4	ned/off center		Г	Positioned V	∟ Vrong	J ~
				Cut Too Short		Mislabe			Γ	Power Loss/		Other	
				Drawing		Misread	1		_	•		•	
	Marks/Chatter Drill Holes				Drill Holes		Off-set						
	Turnin	g Sequence	9		Finish		Out of 0	Calibration					
	Wave/Twist in Tube				Fit/Function		Out of 9	Sequence					

**Picklist Print** June-24-13 1:54:39 PM Work Order ID: 103394 Required Date: 7/05/13 Parent Item: D3208-11 Start Date: 6/24/13 Start Qty: 8.00 Required Qty: 8.00 Parent Item Name: Filler IPP: A04.06.09New issueKJ/RF Comments: IPP B 08.11.17 Waterjet EC verified: DD IPP REV C:PER REV B 12-03-23 JLM VERIFIED BY:EC IPP REV:D 12.04.20 as per dwg rev.C DD verf:EC Component Item ID/ Replacement Last Unit of Qty on Qty per Kit Total Qty Date Status Mfg/ Bin Primary Route Location Item Name Item ID Measure Hand Qty Issued Issued Purch Item Location Seq ID 546.4938 M6061T6S.063 No 100 sf 0.1646 1.3861056 Purchased 13.08.07 6061-T6 .063 Sheet Loc Oty Loc Code Location 546.4938 MAT021 120.2625 123135 79.19 124003 11.0413 125431 126075 [336] M126075

DQA:	Date:									)ΔRT				
QA Closed:		Date:			WORK ORDER NON-	-C(	ONFO	RIMANCE / UPD		Work	: Order up	odate only	7	AEROSPACE
Work Orde	٠,٠,٠		•		DISPOSITION	DISPOSITION AGAINST DEPARTMENT/PROCESS								
WOIK Olde					Rework	1		Skid-tube	Crosstube	$\neg$		Water Jet	] Eng	ineering
Part N	lo				Scrap			<b>├</b>	Small Fab		Pro	d. Eng. Coor.	٦ "	Quality
					Use-as-is		Thern	noforming	Finishing		Rec/Stor	re/Packaging		Other
NCR N	lo				Suspected Unapproved			Large Fab C	Composite			Supplier	_	
Root				Desci	ription of work order update	i	Initial	Action	)		Sign &			
Cause	Date	Step	Qty		or non-conformance	Ch	nief Eng	Descript	ion		Date	Verification	Q	C Inspector
Design		,												
Doc/Data			.										1	
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Material						1								
Operator	_			,									ļ	
Offset/Setup	$\dashv$												1	
Process						1								
Supplier	_													
Training										i				
Transport	$\dashv$													
Unapproved		<u> </u>	<u> </u>	<u> </u>			UTCAT	TCODY				<u> </u>	<u> </u>	
Landin	ig Gear	<del>_</del>			General	FAI	ULT CAT	EGURT	<u> </u>					
	Bending				Bend		lealia/n	rogram	Г	$\neg$	atside Dim	: Г	٦,	· /*
ł	Centre N	ot Conce	ntric	-	BOM/Route	$\vdash$	Grain	rogram	}	_	rer/Under		┥	ure/Forced
ŀ	Cracks	or conce	IIIII	-	Broken/Damage/Defect		Hardwa	ro	}	_	rt Incorrec	<b> -</b>	Set-u	p erature/Cure
ŀ		nk/Ripple	/Wave	-	Burrs		{	on Incomplete/Unqua	atified		rt Lost/Mi	<b> </b>	Weld	srature/cure
ŀ	Cuffs	ny mppie	., *****		Contamination	-	1	ions Incomplete/Uncl	-	_	rt Moved	221118	_	g Stock Pulled
F	Crushing			Countersink	-	4	ned/off center	-		sitioned W	L Vrong		3 Stock Fulled	
<u> </u>				Cut Too Short	-	Mislabe		<b> </b>	_	wer Loss/S		Other		
}	) <del></del>			Drawing		Misread		L	,			Totalet		
ŀ	Marks/Cl	٠.			Drill Holes	-	Off-set	•		_				
ţ	Turning S				Finish	-	ł	alibration						
	Wave/Tw			<b></b>	Fit/Function	$\vdash$	4	onuence		_				

DART AEROSPACE LTD	Work Order:	103394
Description: Filler	Part Number:	D3208-11
Inspection Dwg: D3208 Rev: C		Page 1 of 1

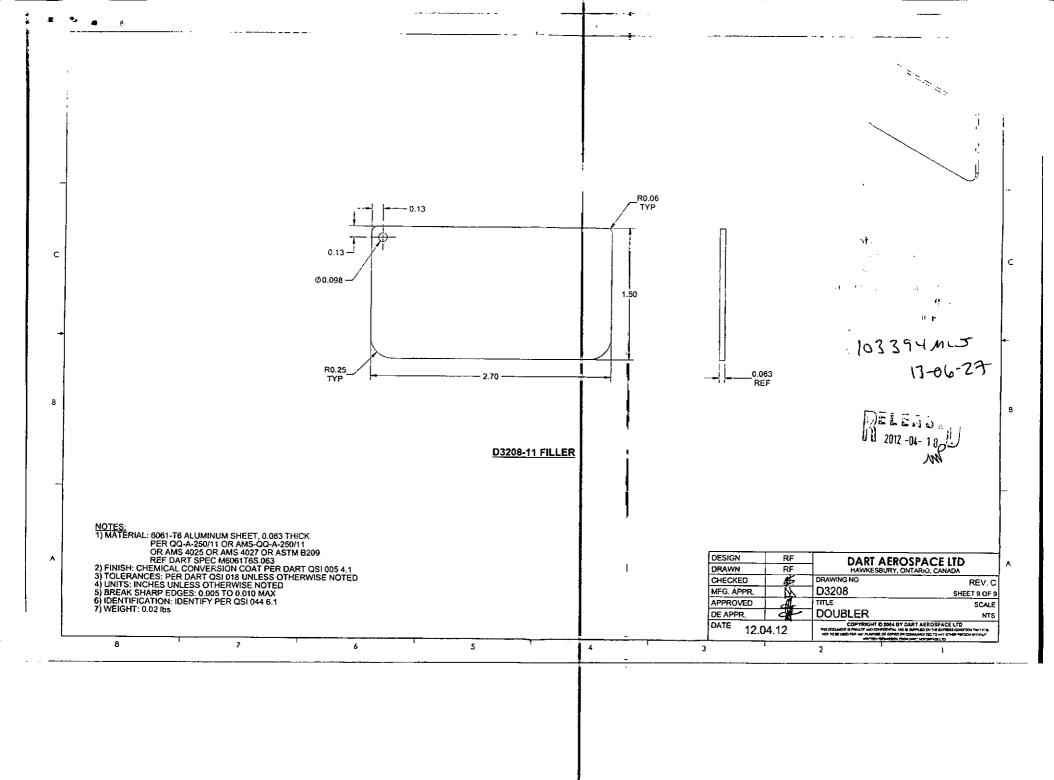
## FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.13	+/-0.030	. 13			V	JKM-01
0.13	+/-0.030	.13			V	
R0.25	+/-0.030	. 25	_		RG	
2.70	+/-0.030	2.70	_		V	
1.500	+/-0.010	1.502	-		V	
R0.06	+/-0.030	00,	_		RG	
Ø0.098	+0.005/-0.000	.100	_		7	
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			26			

Measured by:	Ae	Audited by:	689	Preliminary Approval:	
Date:	13 . 08.07	Date:	1387	Date:	

Rev	Date	Change	Revised by	Approved
Α	05.02.17	New Issue	KJ/JLM_	
В	12.07.31	Dimensions updated per Dwg Rev C	KJ	
C	13.02.27	Dimension 2.70 was 2.30	KJ 😽	

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